

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Work Order ID 140595***140595***

Page 3

January 07, 2016 3:52:53 PM

Item ID: D4103-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step / Handle
Start Date: 1/7/2016 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 2/4/2016 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>5208</u>	0.00							
160									
Packaging	Memo	0.00				<u>40</u>	<u>DAS</u> <u>6</u> <u>9-59</u>	<u>JAN 29 2016</u>	
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00				<u>MCS</u>		<u>JAN 29 2016</u>	
Quality Control									

MCS JAN 29 2016

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Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				

Picklist Print

Page 1

January 07, 2016 3:52:58 PM

Work Order ID: 140595

140595

Parent Item: D4103-1

D4103-1

Parent Item Name: Step / Handle

Start Date: 1/7/2016

Required Date: 2/4/2016

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP REV: A NEW ISSUE 10-07-01 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X03.50 0		Purchased	No			100	f	8.9000	0.52	21.89474			

M6061T6B2 000X03 500

6061-T6 Bar 2.00 x 3.50

**

167-21

Location Loc Qty Loc Code

MAT004

8.9

m132358 r12

8.9

8.9 6.25

8.84

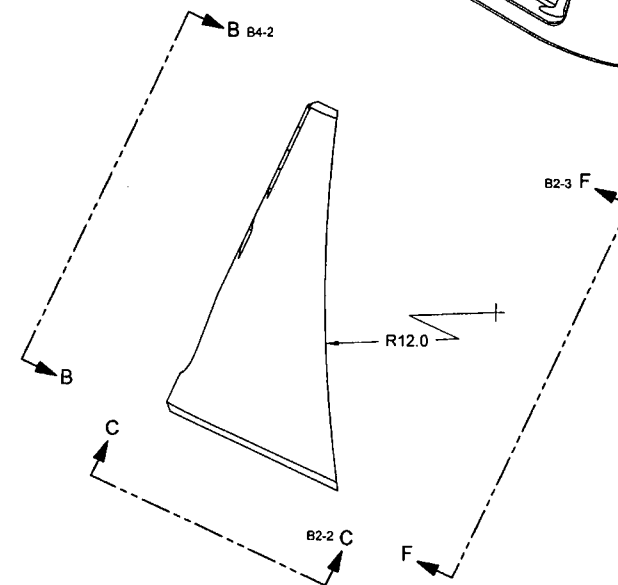
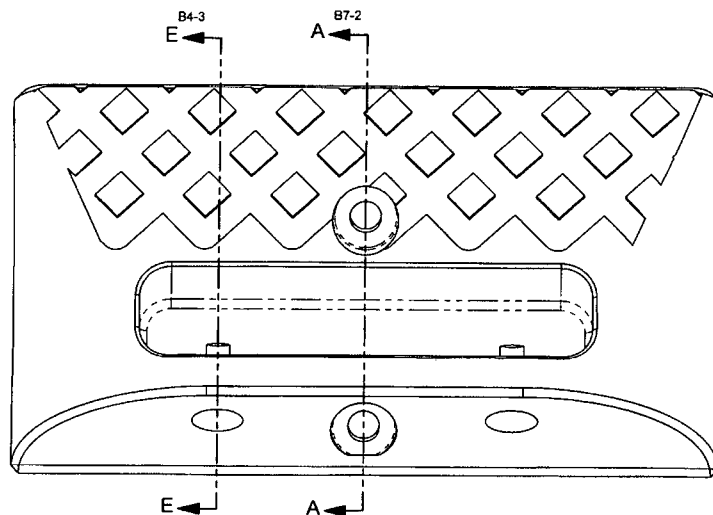
~~134057 x 11 pcs not in system~~

~~qty remaining @~~

1340

134057 x 11 pcs

5.72



D4103-1 STEP/HANDLE

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4103-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.81 lbs
- 8) MACHINE 0.28 x 0.31 GRIP 0.030 DEEP AT 45° PATTERN 0.25 APART

20160107

SH 140595 JWP

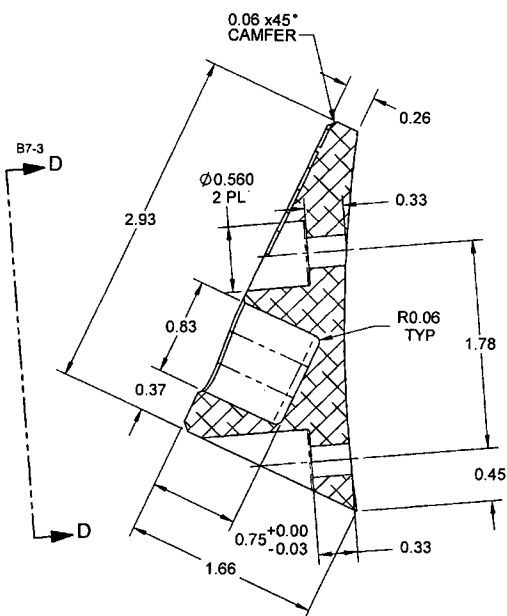
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2010-08-23

A	NEW ISSUE	RF	10.05.17
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DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4103	SHEET 1 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	STEP/HANDLE	NTS
DATE	10.05.17	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

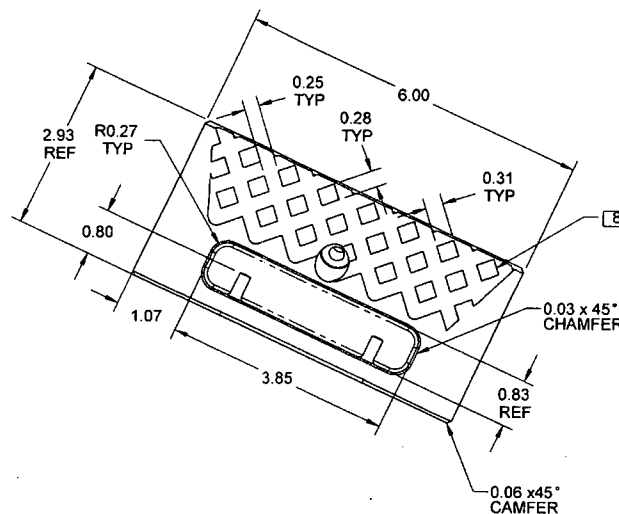
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D
C
B
A

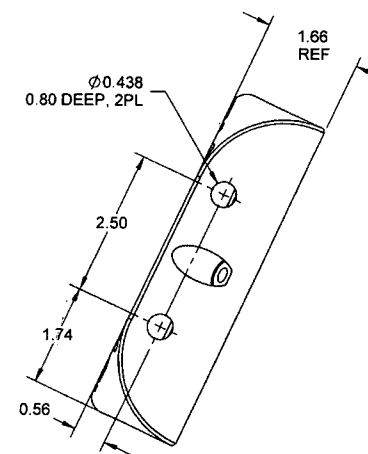
D
C
B
A



SECTION A-A D6-1



VIEW B-B D3-1
SCALE 0.5X

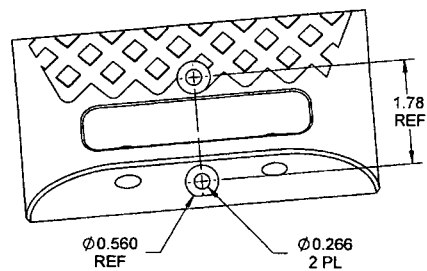


VIEW C-C 82-1
SCALE 0.5X

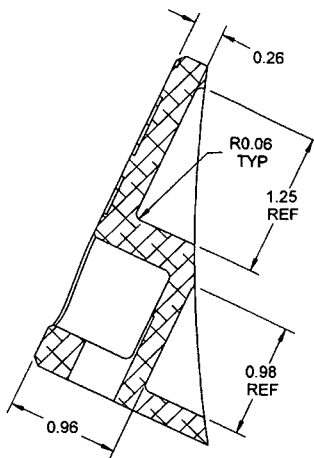
RELEASED
2010-08-23
JNP

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	JNP	DRAWING NO.	REV. A
MFG. APPR.	JNP	D4103	SHEET 2 OF 3
APPROVED	JNP	TITLE	SCALE
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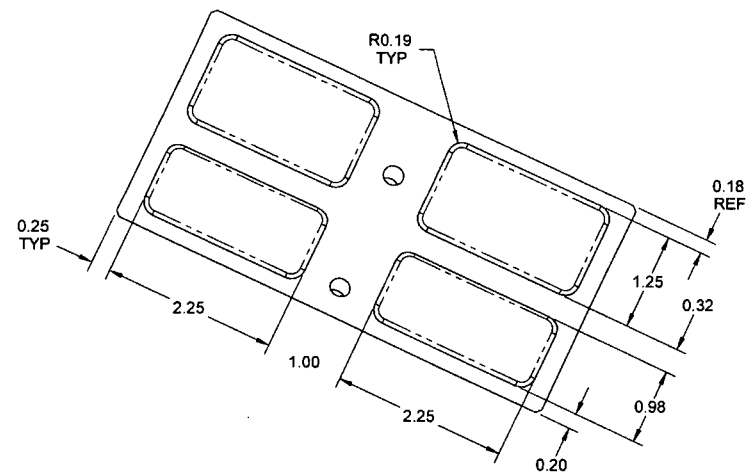
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VIEW D-D C8-2
SCALE 0.5X



VIEW E-E D7-1



VIEW F-F C1-1

RELEASED
2010-08-23
ND

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4103	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 3	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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DART AEROSPACE LTD		Work Order: 140595
Description: Step/Handle		Part Number: D4103-1
Inspection Dwg: D4103	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.93	+/-0.030	2.930	✓		VERN	2L-10
0.37	+/-0.030	0.368	✓		-	
0.83	+/-0.030	0.830	✓		-	
Ø0.560	+/-0.010	0.560	✓		g-PIN	
0.06 X 45°	+/-0.030 X +/-0.5°	0.06 X 45°	✓		VERN	--
0.26	+/-0.030	0.255	✓		-	
0.33	+/-0.030	0.330	✓		-	
R0.06	+/-0.030	R0.060	✓		-	
1.78	+/-0.030	1.780	✓		-	
0.45	+/-0.030	0.449	✓		-	
0.33	+/-0.030	0.335	✓		-	
0.75	+0.000/-0.030	0.750	✓		-	
1.66	+/-0.030	1.652	✓		-	
0.80	+/-0.030	0.800	✓		-	
1.07	+/-0.030	1.074	✓		H-G	
3.85	+/-0.030	3.851	✓		VERN	
0.03 X 45°	+/-0.030 X +/-0.5°	0.03 X 45°	✓		-	
0.31	+/-0.030	0.310	✓		-	
0.28	+/-0.030	0.280	✓		-	
0.030 Deep	+/-0.030	0.030	✓		-	
6.00	+/-0.030	5.998	✓		-	
R0.27	+/-0.030	0.270	✓		-	
0.56	+/-0.030	0.555	✓		-	
1.74	+/-0.030	1.745	✓		H-G	
2.50	+/-0.030	2.500	✓		VERN	
Ø0.438	+0.006/-0.001	0.438	✓		-	
Ø0.266	+0.006/-0.001	0.266	✓		-	
0.96	+/-0.030	0.952	✓		H-G	
0.26	+/-0.030	0.252	✓		H-G	
0.25	+/-0.030	0.245	✓		-	
2.25	+/-0.030	2.250	✓		-	
1.00	+/-0.030	0.999	✓		-	
0.20	+/-0.030	0.196	✓		-	
0.98	+/-0.030	0.980	✓		-	
0.32	+/-0.030	0.320	✓		-	
1.25	+/-0.030	1.250	✓		-	
R0.19	+/-0.030	0.190	✓		-	

Measured by: JH
Date: 16-1-21

Audited by: 45
Date: 2016-01-27

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
A	10.10.07	New Issue	KJ	M